

Work Order ID 165109

Tuesday, August 15, 2017 3:19:38 PM

165109

Page 1

Item ID: D4634-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Panel Assembly
Start Date: 8/21/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: AUG 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4634	G

100

0.00

1000

Small Fab

Memo

0.00

Small Fab

Pick Kit

DAS
6
9-89SEP 22 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Tuesday, August 15, 2017 3:19:39 PM

Page 2

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Tuesday, August 15, 2017 3:19:39 PM

165109

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo PPP16S129	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS 27 9-89
SEP 22 2017
17/9/25
17/9/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Tuesday, August 15, 2017 3:19:42 PM

165109

D4634-041

Required Date: 9/5/2017

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM
Dwg Update DL verf: DD
DL
DL
DL

IPP Rev B
IPP Rev C 13/07/09
IPP Rev D Dwg Update 13/12/23
IPP REV E Dwg update 14/01/09
IPP Rev F Dwg. update 14/02/03
IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5		Manufactured	No			100	Each	11.0000	2	2			
D4652-5 Air Valve, 1.25 Id Disk Type													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF003				11					
				122691				2					
				155417				9					
MS21044-N08		Purchased	No			100	Each	130.0000	8	8			
MS21044-N08 Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				130					
				m131452				12					
				m136502				18					
				m136537				100					
MS24693-BB50		Purchased	No			100	Each	85.0000	8	8			
MS24693-BB50 SCREW													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST288				85					
				m130207				85					

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Tuesday, August 15, 2017 3:19:42 PM

Page 2

Work Order ID: 165109

165109

Parent Item: D4634-041

D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 8/21/2017

Required Date: 9/5/2017

Start Qty: 1.00

Required Qty: 1.00

D4743-1 Manufactured No

100 Each 20.0000 2 2

D4743-1

Speaker Grill

**

DAS
6
9-89

SEP 22 2017

Location

Loc Qty

Loc Code

MF005

20

154770

4

155856

8

164337

8

NAS1149DN832J Purchased No

100 Each 1,962.000 8 8

NAS1149DN832J

Washer

**

DAS
6
9-89

SEP 22 2017

Location

Loc Qty

Loc Code

ST264

1962

M129499

16

M131697

64

M137587

1882

D4634-141 Manufactured No

100 Each 0.0000 1 1

D4634-141

Fwd, Center Ceiling Replacement Panel Assembly

**

DAS
07
9-89

17/09/17

D4646-1 Manufactured No

100 Each 13.0000 2 2

D4646-1

Plenum Cap Assembly

**

DAS
6
9-89

SEP 22 2017

Location

Loc Qty

Loc Code

MF009

13

156116

13

D4728-047 Manufactured No

100 Each 16.0000 1 1

D4728-047

Advisory Light, Fwd

**

DAS
6
9-89

SEP 22 2017

Location

Loc Qty

Loc Code

over001

16

124732

16

Tuesday, August 15, 2017 3:19:42 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Tuesday, August 15, 2017 3:19:42 PM

Page 3

Work Order ID: 165109

165109

Parent Item: D4634-041

D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 8/21/2017

Required Date: 9/5/2017

Start Qty: 1.00

Required Qty: 1.00

D4728-051

Manufactured No

100

Each

12.0000

1

1

D4728-051

Cabin Lights #1

**

Location

Loc Qty

Loc Code

MF001

1

122713

1

over001

11

122713

11

DAS
DAS
6
9-89

SEP 22 2017

PLT1.5M-M

Purchased No

100

Each

2,608.000

7

7

PI T1 5M-M

Tie Wrap

**

Location

Loc Qty

Loc Code

ST570

2608

m129712

2608

DAS
DAS
6
9-89

SEP 22 2017

50-009-2

Purchased No

100

Each

19.0000

1

1

50-009-2

Grommet

**

Location

Loc Qty

Loc Code

ST583

19

m135442

19

DAS
DAS
6
7-89

SEP 22 2017

2351-20-27-C3C

2351-20-27-
Z3CT

Purchased No

100

Each

43.0000

1

1

2351-20-27-C3C

STUD

**

Location

Loc Qty

Loc Code

ST579

43

m128068

2

m130318

41

DAS
6

SEP 22 2017

D4652-3

M 164538

DAS
07
9-89

17/09/22

Tuesday, August 15, 2017 3:19:42 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

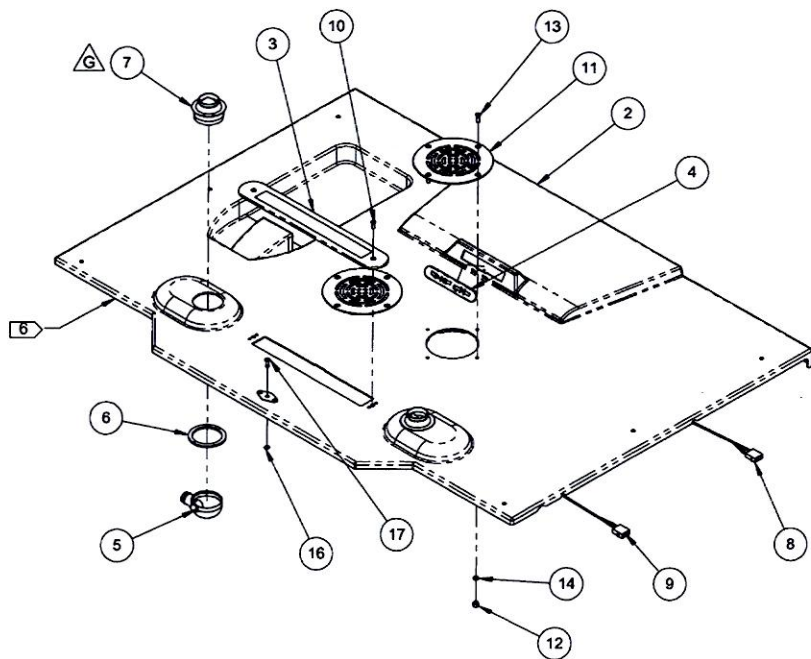


WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER : ☐																							



ITEM NO.	QTY. -041	P/N	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
7	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4638-1)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT, SELF-LOCKING
13	8	MS24693-BB50	SCREW, CSK 100°
14	8	NAS1149DN832J	WASHER
15	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	DZUS STUD, OVAL HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165109 MJS
17-08-16

D4634-041 FWD, CENTER CEILING PANEL ASSY

RELEASED
2015 JAN 26
FCN 14-634 9P

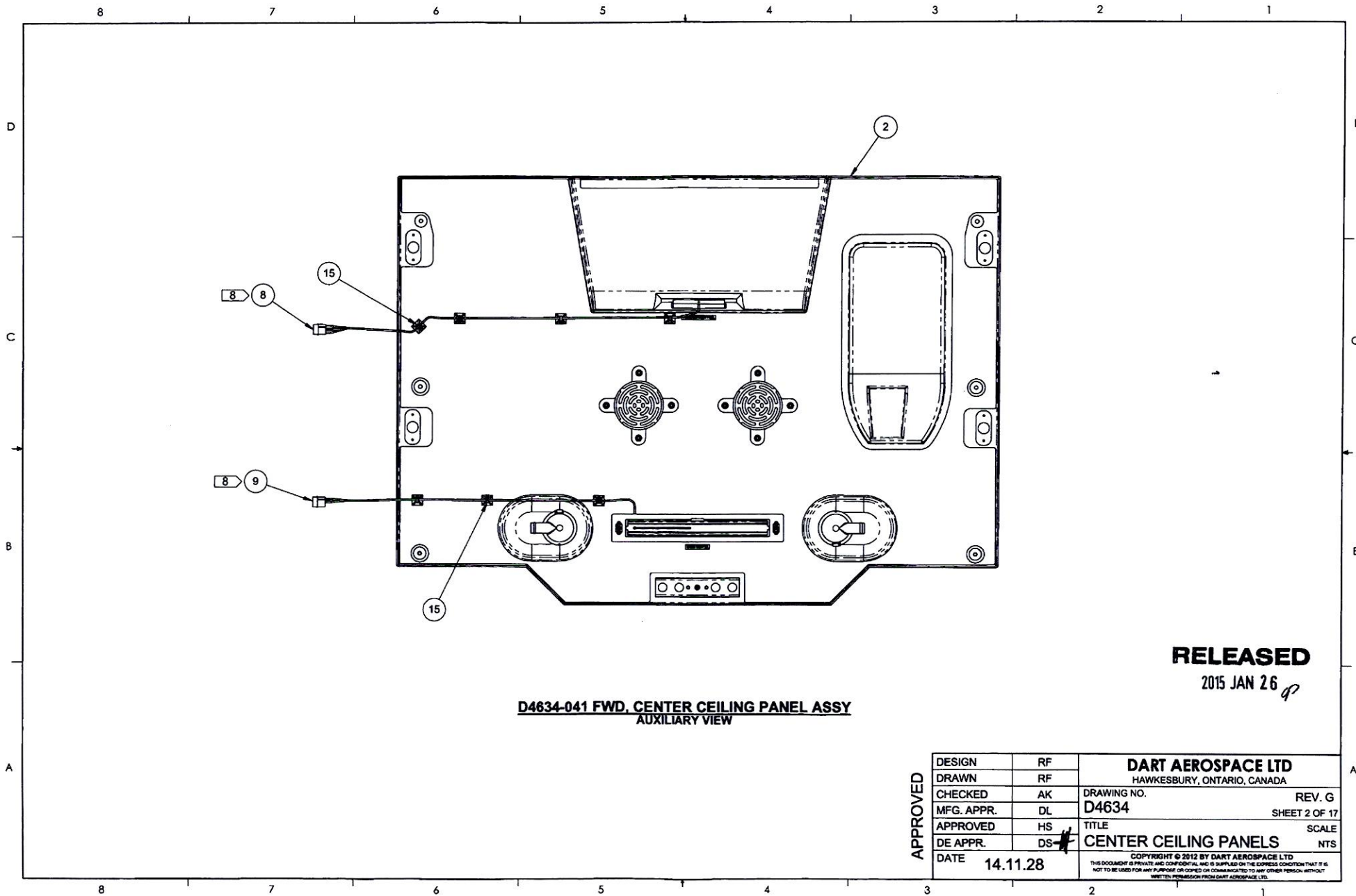
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
 7) WEIGHT: 7.0 lbs
 8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

G	D4652-5 WAS D4652-1 (ZN D4-1, D4-3, D4-5); 10.28 WAS 10.20 (ZN B6-10, B5-12, B5-14); TIE-WRAP & MOUNTING PAD QTY CHANGE; MOUNTING PAD EDGE DISTANCE CHANGE	RF	14.11.28
F	REVISE BOM (ZN D4-7); ADD DIM (ZN B8-9); 10.20 WAS 10.05 (ZN B6-10, B5-12, B5-14); ADD DETAIL V (ZN C4-10, B4-12, C4-14, A4-16); CHANGE PROTRUDE SECTION DIMS TO REF (ZN C7-10, C7-12, C7-14)	RF	14.02.03
E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C6-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-16)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C6-6); D5021-1 (ZN D4-7, D5-7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-750S-9-C (ZN D4-9, B7-9); Ø0.129 (ZN B4-11, B4-13); DETAIL "U" (ZN C2-17); 3.83 WAS 3.87 (ZN C6-11); 2.00 WAS 2.02 (ZN D6-13); REVISE NOTE 8) & 10) (ZN A8-7, A8-8, A9-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/-3/-5; Ø0.250 WAS Ø0.206 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-9); Ø0.206 WAS Ø0.207 (ZN D6-11, C3-13, C6-15) ADD DIM. (ZN B6-7, B7-7, D7-8, & D6-8)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25

REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS		
DATE	14.11.28		

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MFG. APPR.	DL	D4634	SHEET 2 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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